Friday, 01/08/2008 3:28:48 PM

User:

Julie Lecocq

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number**

S.O. No. :

: 40936 : 10509

P.O. Number

This Issue

: 01/08/2008 : NC

: //

: 38026

Type : MACHINED PARTS

Part Number

Drawing Name

: D2564

: MOUNTING ANGLE

: D2564 REV. B1 **Drawing Number**

Project Number **Drawing Revision**

: N/A

Material **Due Date**

: 22/08/2008

Qty:

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By

Comment

: Est:D 02.09.09

Re-format; Added FA276 Folio KJ/RF

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

Angle Extrusion

D6207 1.0

Comment: Qty.: 0.0962 f(s)/Unit Total:

4.8090 f(s)

Angle Extrusion

Material: D6207 (1" x 1" x .125 angle) 6061-T6/T6511 (QQ-A-200/8)

(D6207) BAND SAW

Batch: MIDCUSZ

2.0

Comment: BAND SAW Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



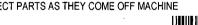
Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA276 Rev: 4 & Dwg D2564 Rev: B1

2-Deburr if necessary

4.0

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



Comment: SECOND CHECK

Dart Ae	rospace	Ltd					
W/O:			WORK ORDER CH	ANGES			
DATE	STEP	PROCEDURE CHANGE			Date 0	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Category:	NCR: Yes	No DQA:	Date: _	, , , , , , , , , , , , , , , , , , ,
				QA:	N/C Closed: _	Date: _	·
NCR:			WORK ORDER NON-CONFO	RMANCE (NC	R)		
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descrip	Section B Sign	& Verificati		Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section E	3	Verification				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
		·								

NOTE: Date & initial all entries

Date: User:

Friday, 01/08/2008 3:28:48 PM

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING ANGLE

Job Number: 40936

Part Number: D2564

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



7.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08-08-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	Ż	PR	OCEDURE CHANGE		Ву	Da	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							·			
		•								
Part No	·		PAR #:	Fault Category:	NCR:	: Yes	No	DQA:	Date: _	
					•	QA: N	N/C C	losed:	Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Annaval	Ammerical			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto			
				·							
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•											

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 1	10936
Description: Mounting Angle	Part Number:	D2564
Inspection Dwg: D2564 Rev: B1		Page 1 of 1

Inspection Dwg	: D2564 Rev :	<u>DI</u>		L		P	age 1 of 1
	FIRST	ARTICLE IN	SPECTIO	ON CHE	CKLIST		
	X	First Artic	le	Prote	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	omments
1.00	+/-0.030	1.002					
0.625	+/-0.010	0.623					
Ø0.257	+/-0.010	0.260					
1.000	+/-0.010	1,001					
1.000	+/-0.010	1.003	1	-			
R0.375	+/-0.010	0.375					
							.,,
					-		
					1		
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	,						
<u> </u>							
							
-				.,,			
<u></u>							
Measured by:	272	Audited by:	4A/C	W/	Prototype App	roval:	N/A
Date:	08/08/07		///	08		Date:	N/A
	1 .7		1 1				

Rev	Date	Change	Revised by	Approx/ed
Α	04.06.10	New Issue	KJ/JLM a	



	DESIG	4	DRAWN BY	DART AEROSPACE LTD		
	MIKE	: M	MIKE M	VICTORIA INTERNATIONAL AIRPORT, CANADA		
١	CHECK	ŒD	APPROVED_	DRAWING NO.	REV.	3
	BI	س	BW	D2564 SHEET	1 OF	1
	DATE			TITLE	SCAL	Ē
	96:0	4:30		MOUNTING ANGLE	1:	1
	В		97:05:06	MODIFIED DIMENSIONS		
	Bi	dil	02.09.17	RO.375 WAS RO.125 OR RO.500;		
				1,00 WAS 1,000		

RELEASE D

			BI		
1.000	••••		1.00		↓
	1.000				0.625
				V _M C	0.257
- R0.1		80.5 00	BI	νc	,,

NOTES:

- I) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125

 MAKE FROM DE207-XXX ANGLE EXTRUSION
- 2) BREAK ALL SHARP EDGES 0.005 0.015
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER